



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-667-107BL
Job Sheet 192114



Part No: D206-667-107BL

Job Qty: 1 pcs

Part Name: Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D206-667-147 REV.B/ IIN-D206-667 REV.D IPP REV:A 12.08.20 DSI9628 revA (ECN12-631) DD
VERF:JLM IPP REV:B 18.09.13 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		4/19/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		GP 19-03-27
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S166984



Part: D206-667-107BL

Job No: 192114

Serial No/Batch: S166984

Revision: B/D

Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAI

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	Crosstubes - Bend - 2 - B4B	1 pcs	4/19/19	0.00 4.32	Crosstubes - Bend - B4B	GP 19-03-27
130	QC 15	1 pcs	4/19/19	0.00 0.00	QC 15 - 12	
					QC 15 - 3	
					QC 15 - 47	
					QC 15 - 49	
					QC 15 - 58	
					QC 15 - 9	
140	Crosstubes - 2 - B4B	1 pcs	4/19/19	0.00 2.87	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	GP 19-04-03
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
150	Crosstubes - 3 - B4B	1 pcs	4/19/19	0.00 0.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	GP 19-04-03
					Crosstubes - 4 - B4B	
160	QC 7	1 pcs	4/19/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
170	QC 5	1 pcs	4/19/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	

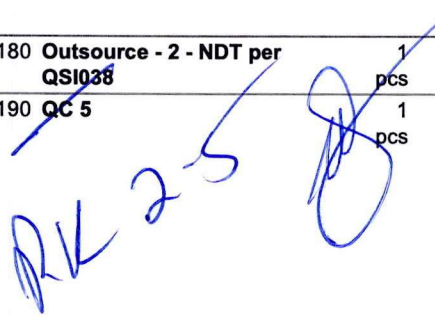
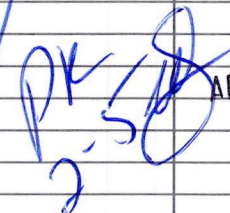
DAS
68
9-89

APR 02 2019 PD

GP 19-04-03

GP 19-04-03

DAS
APR 03 2019 68
9-89

				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS
				QC 5 - 9	APR 03 2019 68
				QC 5 - 50	9-89
				QC 5 - 30	
				QC 5 - 40	
180 Outsource - 2 - NDT per QSI038	1 pcs	4/19/19		SKY002-VC	68-6
190 QC 5	1 pcs	4/19/19	0.00 0.00	QC 5 - 10	84
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 QC 5	1 pcs	4/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS
				QC 5 - 9	APR 11 2019 68
				QC 5 - 50	9-89
				QC 5 - 30	
				QC 5 - 40	
205 Spray Paint - 2 - B4B	1 pcs	4/19/19	0.00 0.00	Spray Paint - 1 - B4B	RD 19-4-11
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
210 Outsource - 2 - NDT per QSI038	1 pcs	4/19/19		ATE003-VC	NR
215 Packaging 2-1 - Receive - B4B	1 pcs	4/19/19	0.00 0.00	Packaging 2 - 1 - B4B	NR
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	

				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
220 QC 14	1 pcs	4/19/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	• AS 19-4-17
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
230 Crosstubes - 4 - B4B	1 pcs	4/19/19	0.00 2.87	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	• AS 19-4-20
240 QC 5	1 pcs	4/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

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				QC 5 - 30	
				QC 5 - 40	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	4/19/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	P.C. APR 24 2019
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	4/19/19	0.00 0.00	QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	DAS 69 9-89
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	DAS 69 9-89
270 Packaging 3-1 - Stock - B4B	1 pcs	4/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
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				Packaging 3 - 16 - B4B	
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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	4/19/19	0.00 0.00	DC - 1 - B4B	DAS 21 APR 25 2019
	pcs			DC - 2 - B4B	
280 QC 21 - FG	1	4/19/19	0.00 0.00	QC 21 - FG - 21	DAS 21 APR 25 2019
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	3-SS

Part Op 110 - (Pick Kit)

Descriptions: 120 - (CNC Alpha 160 Bender) Bend tube as per Dwg D206-667-147 using CNC bender program

130 - (QC15- Crosstube Dimensional Check)

140 - (Crosstubes) ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED

BY: ***** 1- Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill all (3) top holes. Holes facing inboard. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED

BY: ***** 2- Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147. Note: Fwd side has 3x top holes. Facing inboard. 3- C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins .Drill ONLY 2 top holes ONLY plug most bottom holes to prevent accidental drilling. Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill only the top (2) holes. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 5- Drill Aft rivet holes using drill Jig

150 - ***IMCrosstubes Chemical Conversion) MEDIATLY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (QC5- Inspect part completeness to step on W/O)

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - (QC5- Inspect part completeness to step on W/O) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - (QC5- Inspect part completeness to step on W/O) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____

BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH

W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per

QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____

PAINT:DELFLFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLFLEET B _____

215 - (Receive & Inspect for Damage & Mat'l Certs)

220 - (QC14- Inspect Spray Paint) Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

230 - (Crosstubes) INSTALL GROUNDING CLAMP AND SEAL WITH SIKAFLEX AS PER DWG A/R SIKAFLEX

BATCH: _____ 1-Abraide mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2-Install supports with Proseal 890 per D206-667-147 and QSI 015 A/R Proseal 890

Batch: 5146134 EXP: 19/10 3-Install supports clamps Using Dt9565 as per Dwg D206-667-

147 ,Torque to 80-100 IN-LBS. PROSEAL CURE TIME 72 HOURS: Start: 19-4-11

Finish: 19-4-14 4-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron paint. 5- Install grounding strap as per dwg (D206-667-017)

240 - (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.*** **VERIFY RESISTANCE

AS PER NOTE 18 AND DWG*** **VERIFY BY _____ BATCH # TO MATCH W/O _____

***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND

009443

VERIFY***

250 - (Pick Kit)

260 - (QC4- 100% Inspect kits for completeness) ***VERIFY BY _____ BATCH # TO MATCH W/O

***VERIFY BY _____ PART # TO MATCH W/O

270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D206-667-107

Location:FG035

275 - Photocopy bluefile and create labels as per PPP D206-667-107 chg 003

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-147TRN	Crosstube Assembly, Mid Fwd	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	484
D206-667-017	Grounding Strap	1 pcs (1 ea)	230-Crosstubes - 4 - B4B	
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
D2873-045	Nut Plate Assembly	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
D2891-1	Support 2.25	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
D3595-063-395	Rubber Cushion 0.63" Wide X 3.95" Long	4 pcs (4 ea)	230-Crosstubes - 4 - B4B	
MS20601-AD4W8	Rivet	14 Ea (14 ea)	230-Crosstubes - 4 - B4B	
MS21920-20	Clamp	4 Ea (4 ea)	230-Crosstubes - 4 - B4B	
AN742D36	Plain Clamp Loop	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
MS21042-3	Nut use MS21042L3 per QSI 017	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
MS27039-1-08	Screw	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
MS9165-05	Bracket	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
NAS1149C0332R	Washer	4 Ea (4 ea)	230-Crosstubes - 4 - B4B	
AN5-30A	Bolt	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5104362
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5058983
AN5-7A	Bolt	10 Ea (10 ea)	250-Packaging 1-1 - Pick Kit - B4B	FM123355
AN970-4	Washer	12 Ea (12 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166689
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149145
NAS1149D0563J	Washer	18 Ea (18 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167648

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D206-667-147TRN	1	4	0
230-Crosstubes - 4 - B4B	AN742D36	2	15	0
	D206-667-017	① 5157529	12	0
	D2873-043	② 5145379	75	0
	D2873-045	② 5133728	42	0
	D2891-1	② 5152245	10	0
	D3595-063-395	⑤ 5103943	57	0
	MS20601-AD4W8	④ 5103847	182	0
	MS21042-3	2	662	0
	MS21920-20	④ 5103354	103	0
	MS27039-1-08	2	546	0
	MS9165-05	2	11	0
	NAS1149C0332R	4	5,103	0
250-Packaging 1-1 - Pick Kit - B4B	AN5-30A	4	30	0
	AN5-32A	4	385	0
	AN5-7A	10	3,153	0
	AN970-4	12	72	0
	MS21042L5	4	723	0
	NAS1149D0563J	18	1,495	0

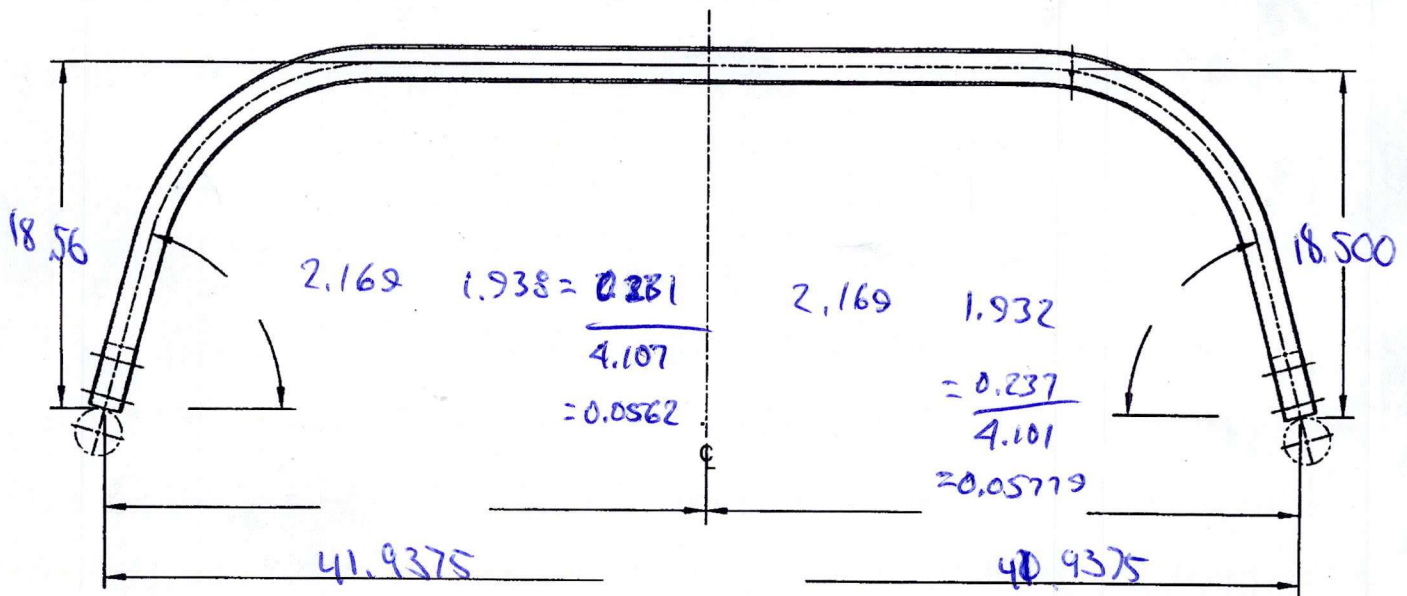
Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD	Work Order: 192114
Description: Crosstube Mid Fwd (206L)	Part Number: D206-667-107
Inspection Dwg: D206-667-147 Rev: A	Page 1 of 1

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	10	11
Crushing	5.6%	5.8%
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	PROSEAL	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

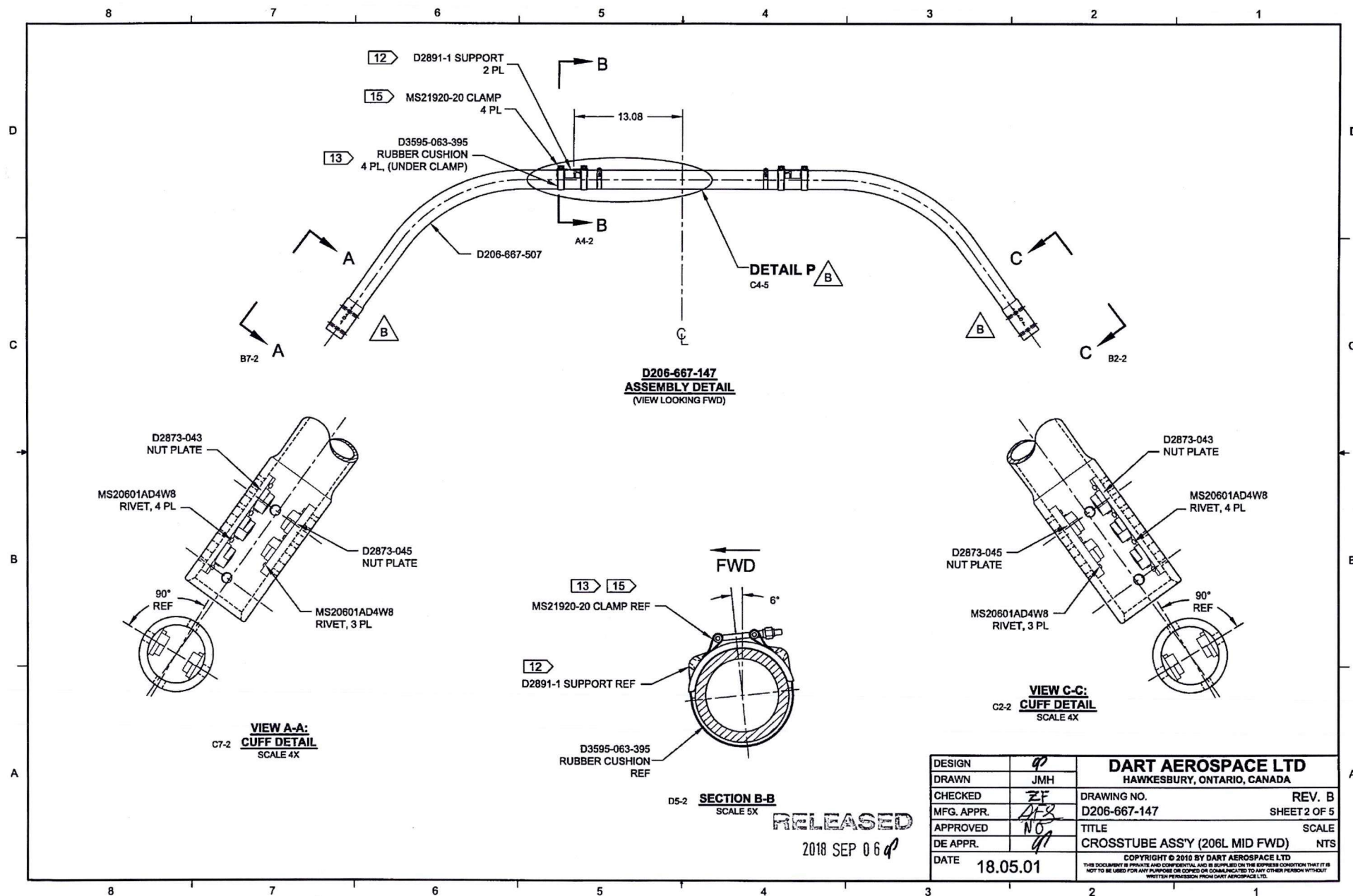
- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 8% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MEGOHMS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192114 MJS
19-03-18

RELEASED

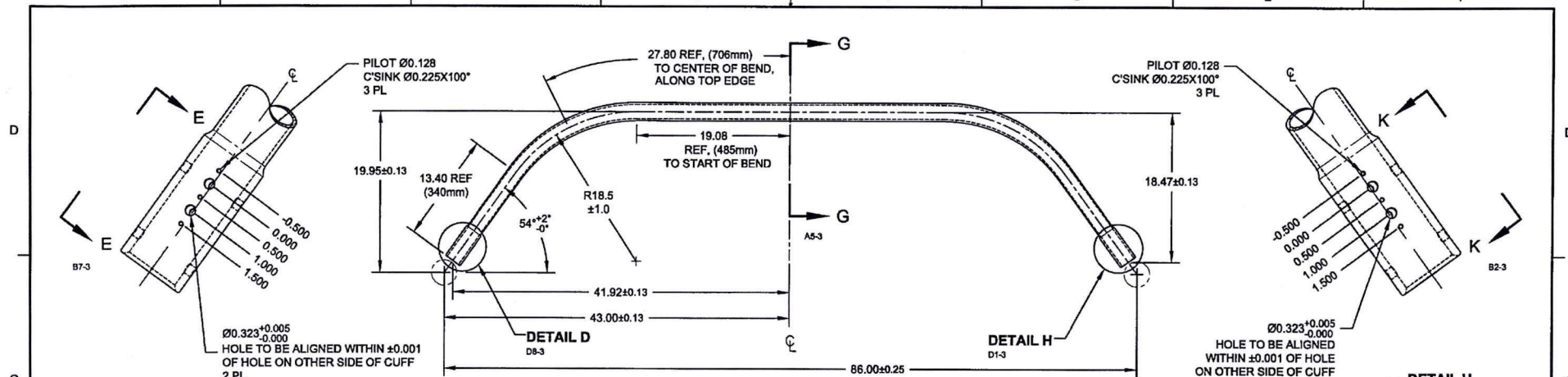
2018 SEP 06
EN 14-717 4

B	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO A-1. ADD ITEMS 10-14 TO PARTS LIST, ADD GENERAL NOTES 16-18 AND ADD SHEET 5 TO INCORPORATE DEO A-2.	JMH	18.05.01
A	NEW ISSUE	CP	10.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH	DRAWING NO.	REV. B
CHECKED	ZE	D206-667-147	SHEET 1 OF 5
MFG. APPR.	AS	TITLE	SCALE
APPROVED	NO	CROSSTUBE ASSY (206L MID FWD)	NTS
DE APPR.	JP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	18.05.01		



DESIGN	97	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DFB	D206-667-147	SHEET 2 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASS'Y (206L MID FWD)	NTS
DATE	18.05.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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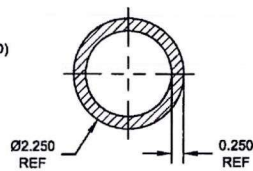
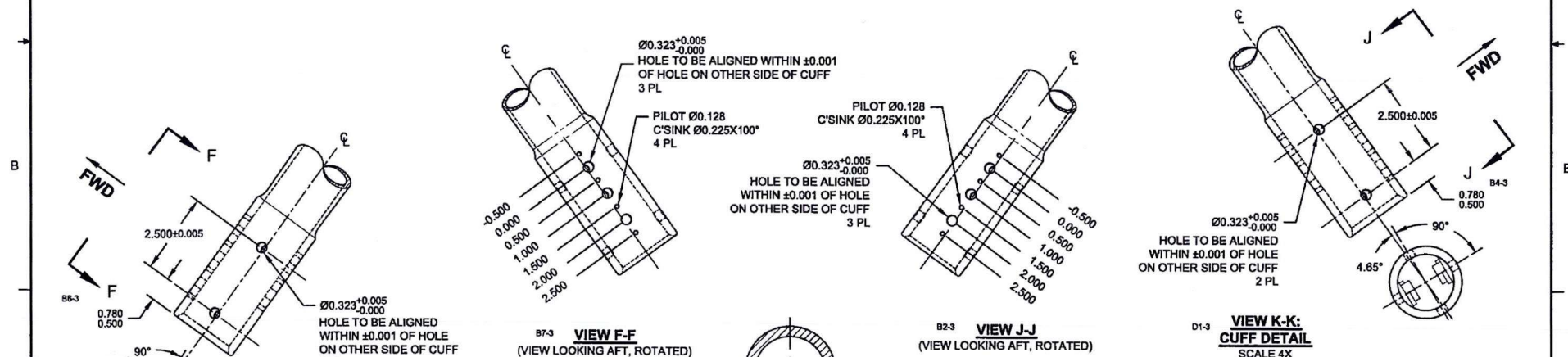
8 7 6 5 4 3 2 1



C6-3 **DETAIL D**
SCALE 4X
(VIEW LOOKING FWD)

10 **D206-667-507**
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)

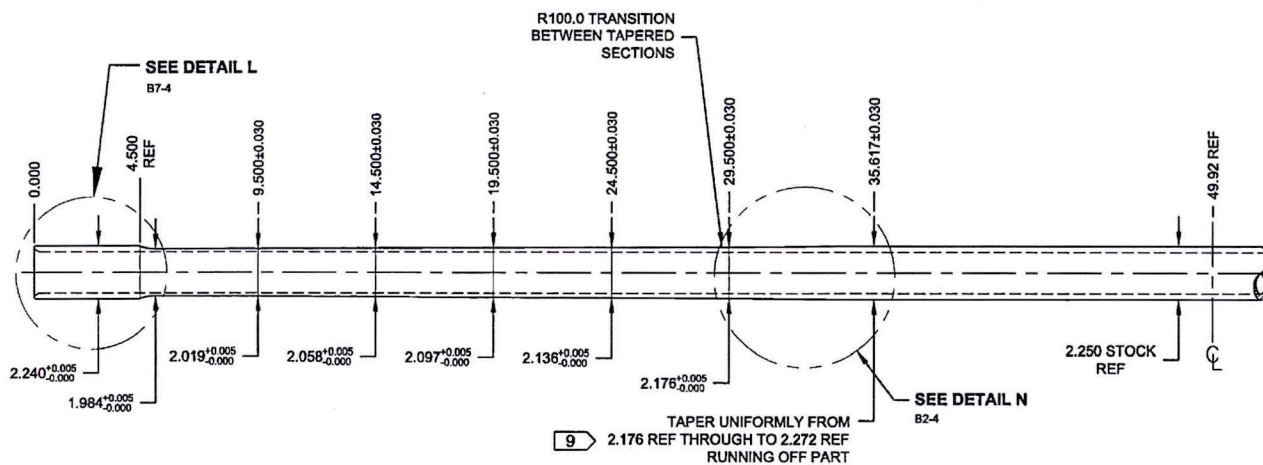
C3-3 **DETAIL H**
SCALE 4X
(VIEW LOOKING FWD)



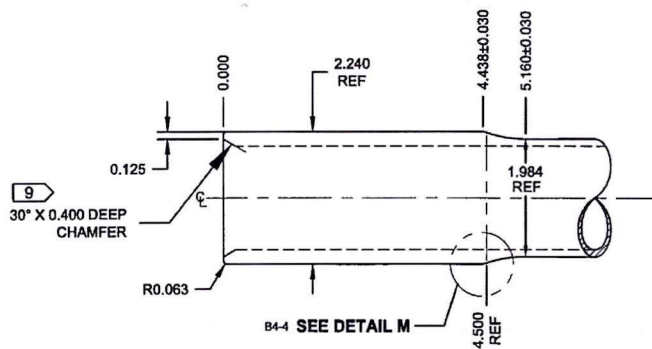
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2018 SEP 06

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	AFS	D206-667-147	SHEET 3 OF 5
APPROVED	No	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L MID FWD)	NTS
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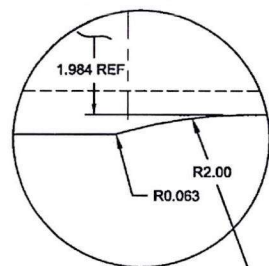
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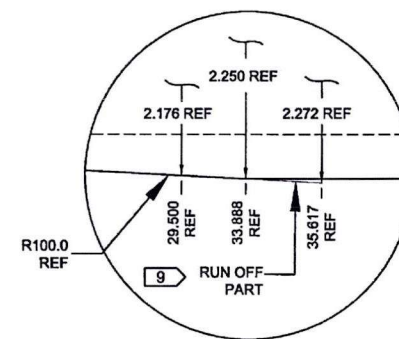
TURNING DETAIL



D7-4 **DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE



A8-4 **DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

RELEASED
2018 SEP 06

DESIGN	97	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	ZFS	D206-667-147	SHEET 4 OF 5
APPROVED	N/O	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASS'Y (206L MID FWD)	NTS
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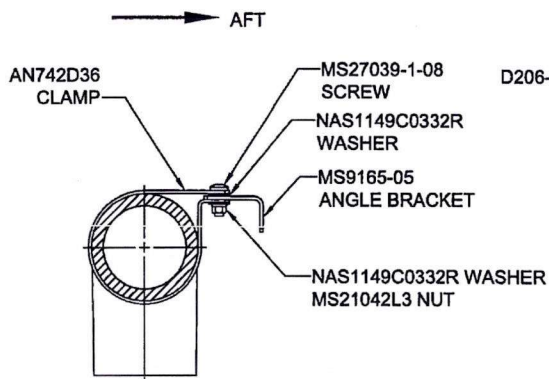
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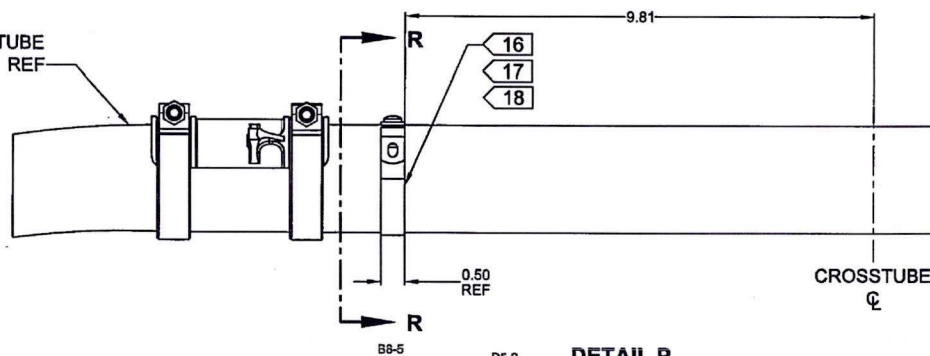
C

B

A



D206-667-507 CROSSTUBE
REF



D5-2
BONDING STRAP INSTALLATION 2 PL

RELEASED

2018 SEP 06

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	278	D206-667-147	SHEET 5 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	9P	CROSSTUBE ASS'Y (206L MID FWD)	NTS
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8 7 6 5 4 3 2 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043076



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043076

PO Date: 4/3/19

Due Date: 4/11/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
APR 10 2019

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192114	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192115		1 X APR 11 2019	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192116		1 X APR 11 2019	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							3	0	3		\$395.63



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043076



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	192117	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed -	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192118			Firmed -	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							2	0	2		\$263.75
3	190489	D135-1027-251	Std Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed -	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
4	191900	D135-1027-253	Mid Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed -	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	191901			Firmed -	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							2	0	2		\$263.75
Grand Total:										\$1,055.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO043076



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL

Plex 4/10/19 12:39 PM dart.lavoie.chantal

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO39884	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO043076 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 8 CROSSTUBES

ITEM ID: D135-1027-251 STB HEIGHT AFT CROSSTUBE

1 - WORK ORDER ID#: 190489 ✓

ITEM ID: D135-1027-253 MID HEIGHT AFT CROSSTUBE

2 - WORK ORDER ID#: 191900 ✓

3 - WORK ORDER ID#: 191901 ✓

ITEM ID: D206-667-107BL FWD CROSSTUBE - MID HEIGHT 206L / L1 / L3 / L4, BLUE.

4 - WORK ORDER ID#: 192114 ✓

5 - WORK ORDER ID#: 192115 ✓

6 - WORK ORDER ID#: 192116 ✓

ITEM ID: D206-667-207BL

7 - WORK ORDER ID#: 192117 ✓

8 - WORK ORDER ID#: 192118 ✓

Action Taken:					Date:		Initial/Stamp:	
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-8) AS PER ASTM1417M-16					APR 6 5 2019		DOT-APP 61 53-89 ✕	
NO CRACK FOUND								
PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO23451, UV LIGHT M-20142								
Description	Location	P/N	Qty	Batch	S/N Off	S/N On		

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 		ACA/SCA Stamp DOT-APP 61 53-89	Date: APR 6 5 2019
Name: ANTONINO MARCHETTA			